

Work Order ID 70379

Monday, June 06, 2011 9:26:25 AM



Page 1

Item ID: D3805-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 6/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/06/06 Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3805

PC1

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3805

Dwg Rev: PC1

Prog Rev: PC1

2-Deburr if necessary

SCHAP

0.00

B11-66



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-66



PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70379

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Brake NC

0.00



Brake NC

Memo

Form as per Dwg D3805 using Jigs DT8261 and DT8326

0.00

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

ME
11-09-14

W/O: 7037		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D38057 PAR #: _____ Fault Category: Eng/Design NCR: Yes ~~No~~ DQA: _____ Date: _____
 Resolution: Design Scrap Disposition: Scrap QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/13	#120	Parts to be Scrapped Design change	11/09/13	Scrap all Parts no Reple	Ac 11.09.13	S 11/09/13	11/09/13	S 11/09/13

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, June 06, 2011 9:26:23 AM

Work Order ID: 70379



Parent Item: D3805-1



Parent Item Name: Plate



Start Date: 6/6/2011

Required Date: 6/17/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC
 IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC
 IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 		Purchased	No			100	sf	175.9000	3.8542	16.22821			
											811-6-6		

304/316 .050 Sheet

Location

Loc Qty

Loc Code

MAT020

175.9

112178

3.4

113062

18

116135

17

116604

1.5

116979

69

117653

67

112178

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 70379
Description: PLATE		Part Number: D3805-1
Inspection Dwg: D3805-1, Rev: PC1		Page 1 of 1

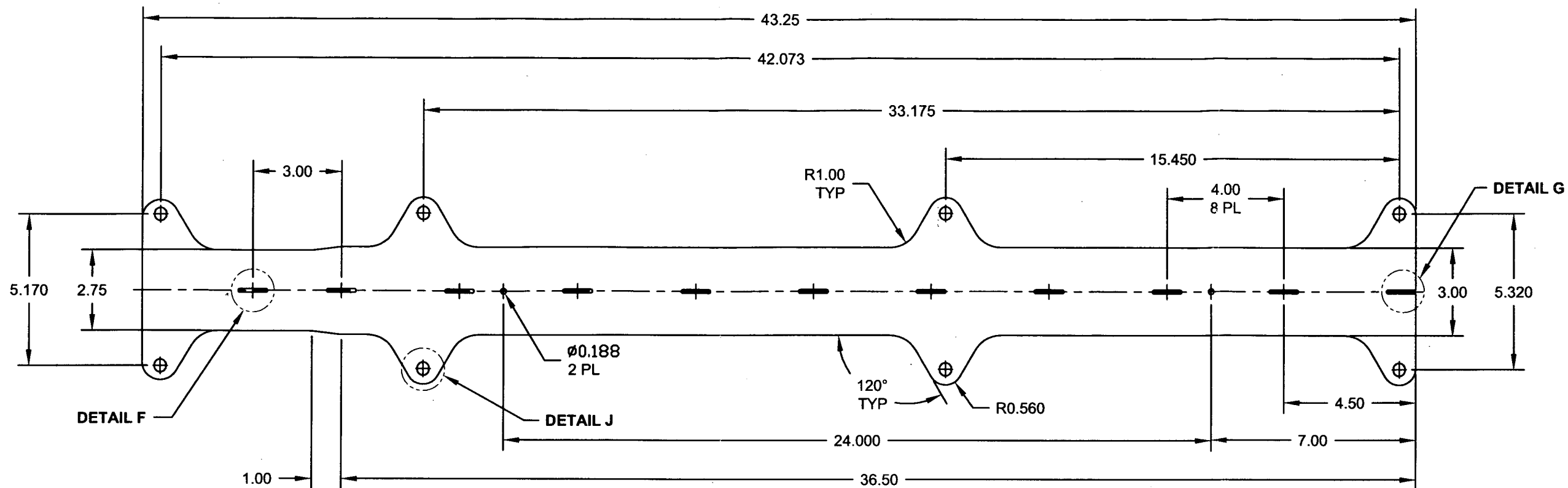
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

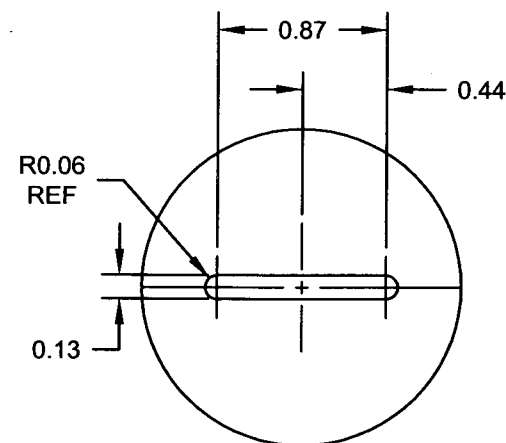
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.40	± .030	.401	X		V RBZ	
.94	± .030	.933	X		V	
.87	± .030	.874	X		V	
.13	± .030	.128	X		V	
2.15	± .030	2.157	X		V	
5.170	± .010	5.167	X		V	
3.00	± .030	3.018	X		V	
1.00	± .030	1.000	X		V	
5.320	± .010	5.320	X		V	
4.50	± .030	4.50	X		V	
7.00	± .030	7.001	X		V	
4.00	± .030	3.999	X		V	
24.000	± .010	24.00	X		T RBZ	
36.50	± .030	36.50	X		T	
15.450	± .010	15.450	X		T	
33.175	± .010	33.175	X		T	
42.073	± .010	42.073	X		T	
43.25	± .030	43.25	X		T	
.050	± .010	.047	X		V	
.188	± .005 - .001	.190	X			

Measured by: RB	Audited by:	Prototype Approval:
Date: 11-6-7	Date:	Date:

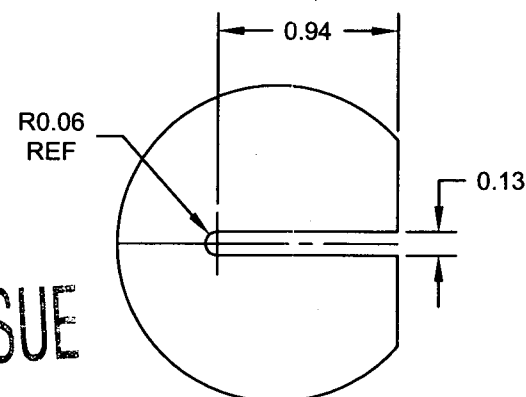
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



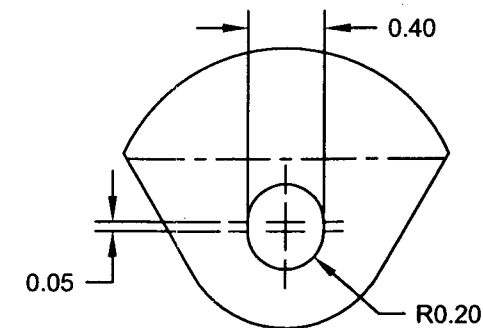
D3805-1F PLATE



DETAIL F
SLOT DETAIL TYP
SCALE 4X



DETAIL G
SCALE 4X



DETAIL J
SCALE 4X

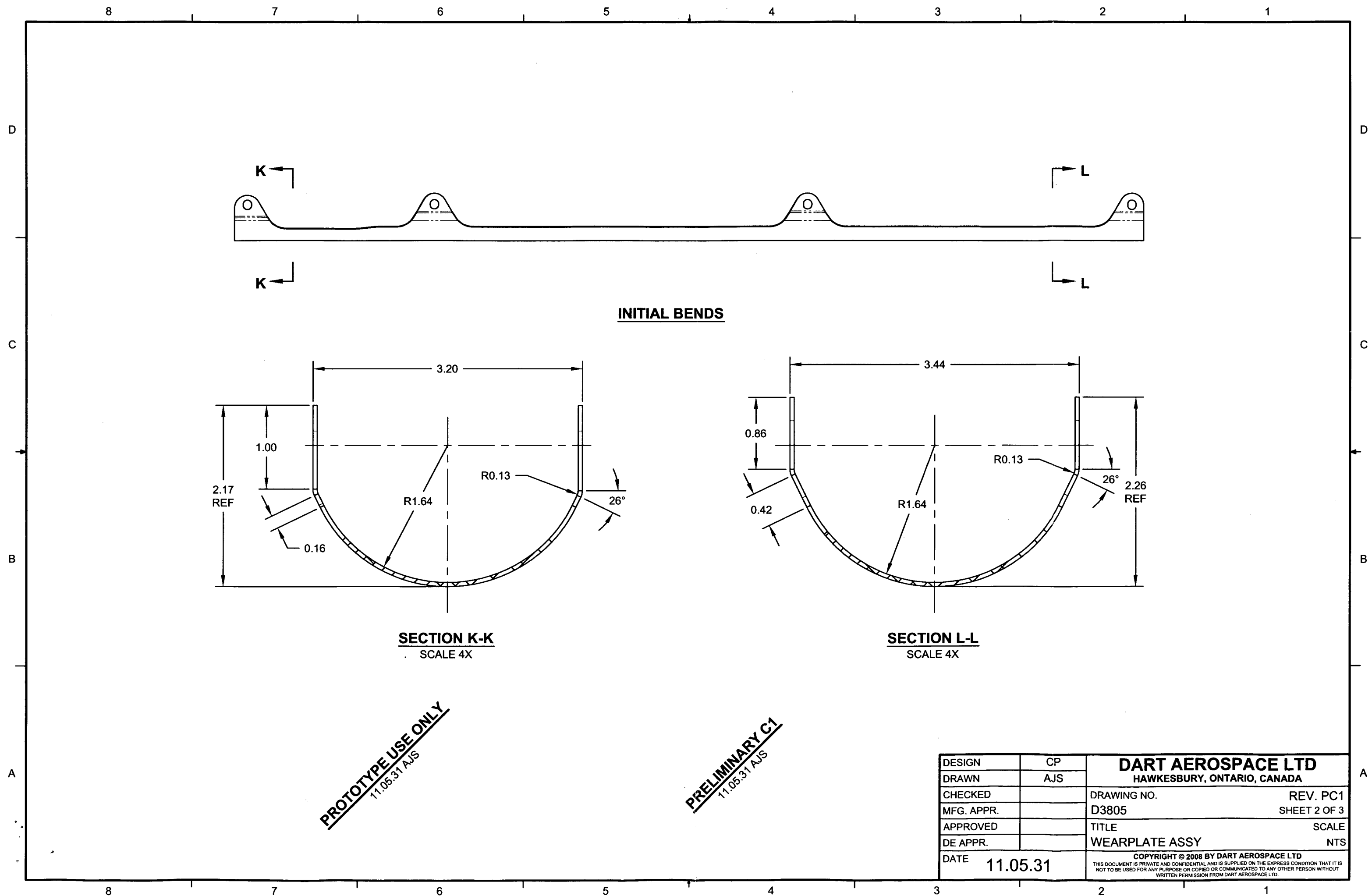
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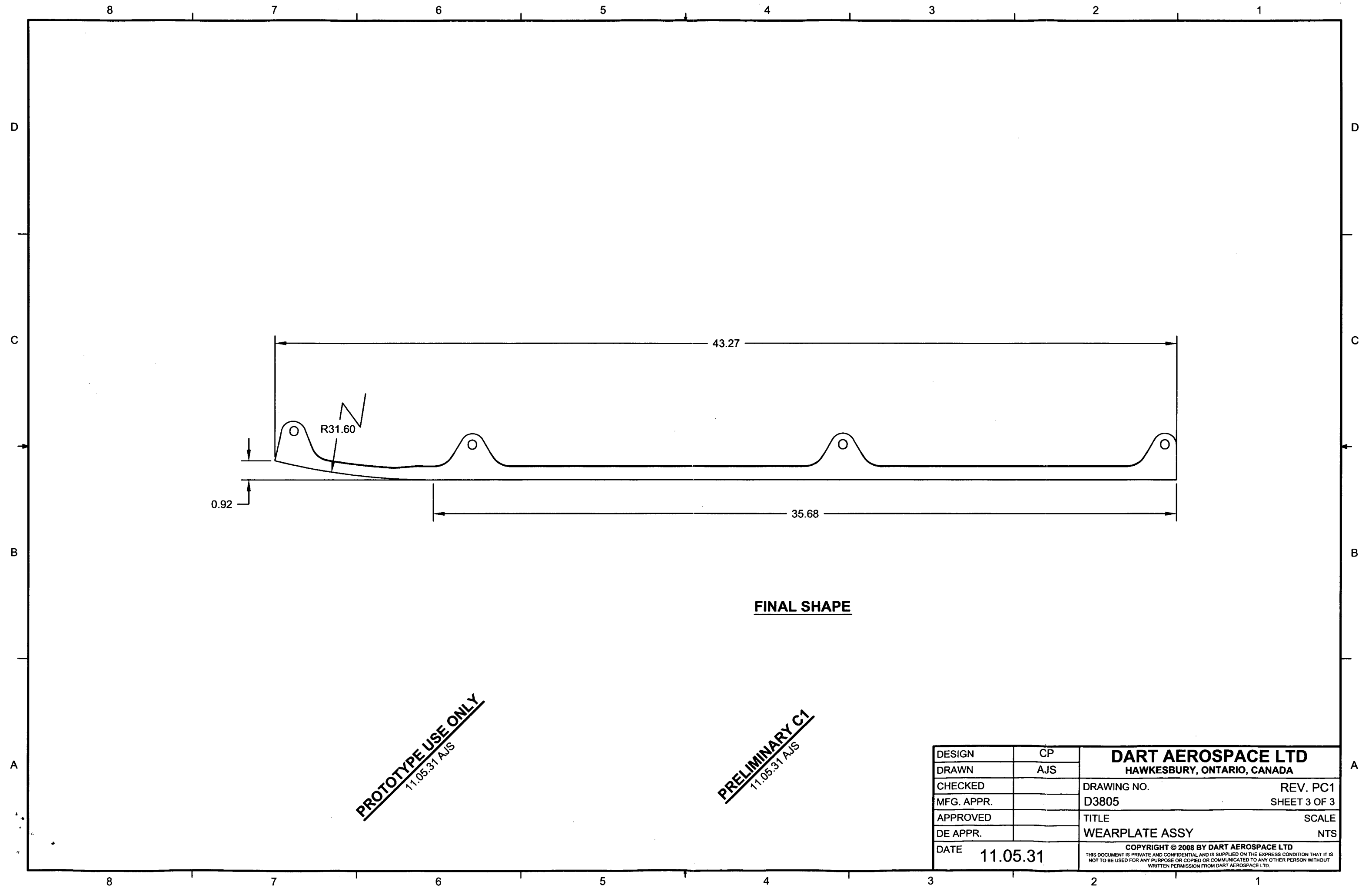
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.11 lbs

PROTOTYPE USE ONLY
11.05.31 AJS

PRELIMINARY C1
11.05.31 AJS

PC1	PRELIMINARY	AJS	11.05.31
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PC1
MFG. APPR.		D3805	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PC1
MFG. APPR.		D3805	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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